


Work Order ID 111850

111850

Page 1

January-23-14 2:38:48 PM

Item ID: E4736-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Service Deck Drain Line Assembly
 Start Date: 24/01/2014 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 28/02/2014 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan:  Date: 14-01-23 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
E4736	

100 0.00
 100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 22800

Fabricate as per dwg E4736

Purchase Part Number: E4736-1
 Supplier: FIELD AVIATION
 Certificate of conformity is required

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging Memo 0.00
 Packaging

CL 14/01/27 5

Recy 14/2/2 (5)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Work Order ID 111850

111850

Page 2

January-23-14 2:38:48 PM

Item ID: E4736-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Service Deck Drain Line Assembly
 Start Date: 24/01/2014 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 28/02/2014 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 DAS 27 9.89 14/4/3				S			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo 5x PPP 111858	0.00 0.00				5x		DAS 28 9.89	APR 03 2014
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							14-04-3 14-04-3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Print

January-23-14 2:39:00 PM

Page 1

Work Order ID: 111850

111850

Parent Item: E4736-043

F4736-043

Parent Item Name: Service Deck Drain Line Assembly

Start Date: 24/01/2014

Required Date: 28/02/2014

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 14-01-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

E4736-043P

Purchased

No

Each

0.0000

5

F4736-043P

Service Deck Drain Line Assembly

P-17/4/2 (5)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

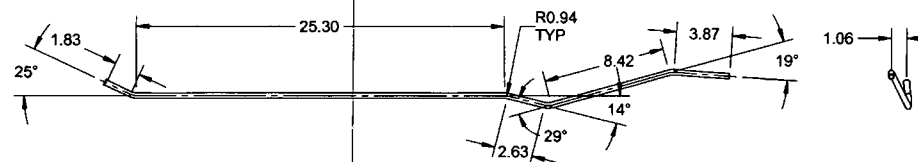
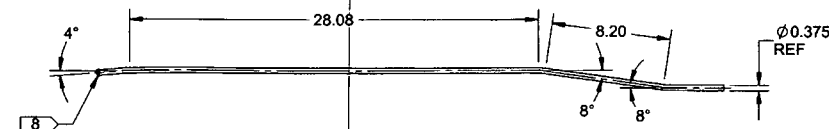
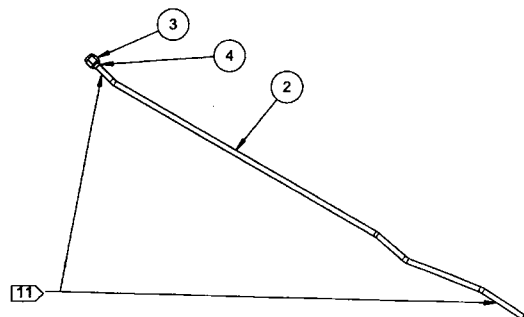
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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*ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	E4736-041	DRAIN LINE ASSEMBLY
2	1	E4736-1	TUBE
3	1	AN818-6D	NUT COUPLING
4	1	MS20819-6J	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.94	1.79	23.0°	0.0°
2	0.94	27.77	16.0°	180.0°
3	0.94	30.79	33.0°	355.0°
4	0.94	39.66	23.0°	173.0°
END B - TL	-	44.03	-	-



E4736-041 FUEL FILTER DRAIN LINE ASSEMBLY

E4736-1 TUBE

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.375 \times 0.035$ WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T4T0.375W.035
OR
5052-O ALUMINUM ROUND TUBING, $\phi 0.375 \times 0.035$ WALL
PER AMS-WW-T-700/4 OR ASTM-B-210-02
REF DART SPEC. M5052-OT0.375W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 200 PSI
- 10) MARK LINE WITH BRADY B-999 "FUEL" & "DRAIN" TAPE IN LOCATIONS SHOWN

111850 MP
14-01-23

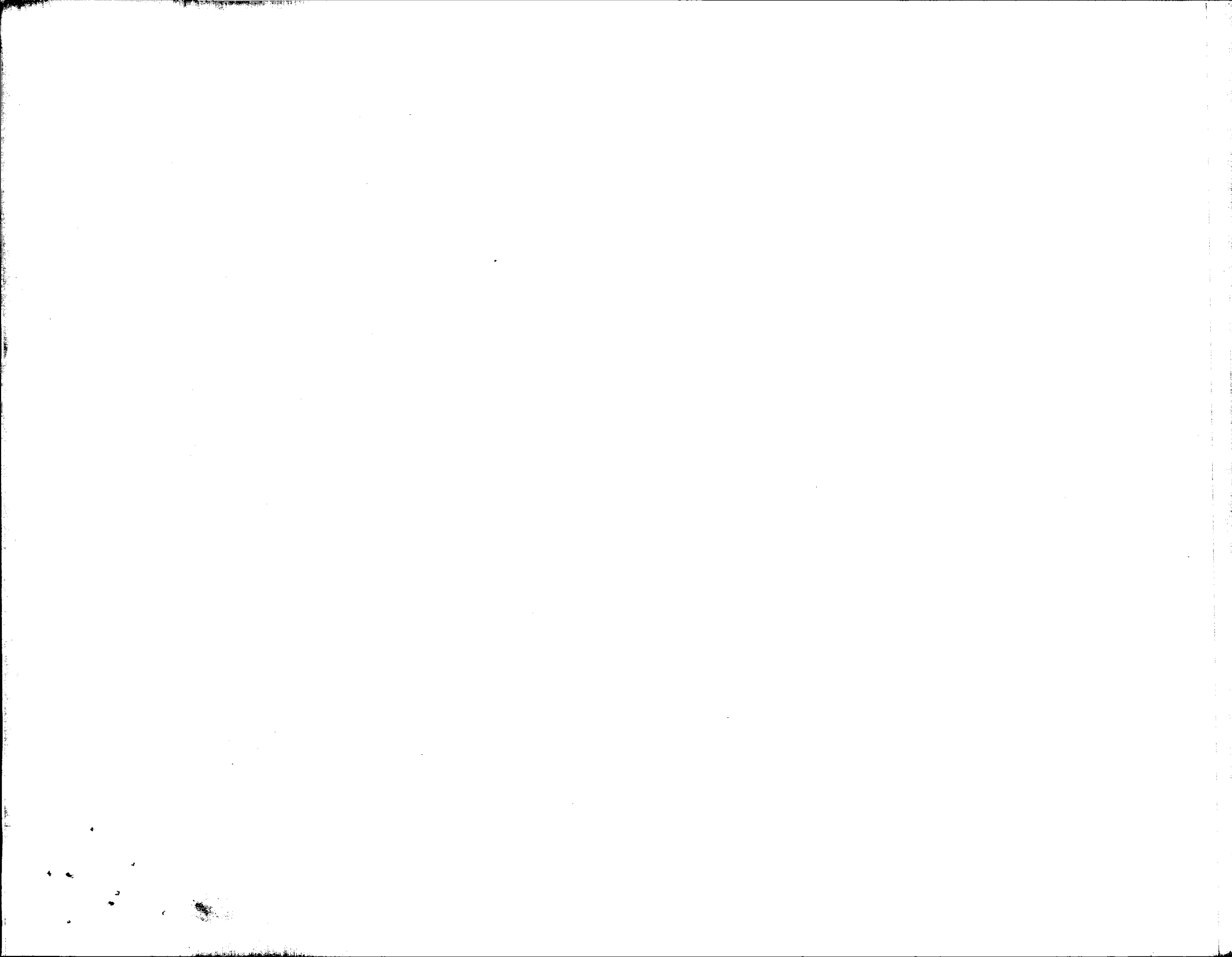
A	NEW ISSUE	DC	12.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.01		

EAGLE COPTERS LTD
CALGARY, ALBERTA, CANADA

DRAWING NO. **E4736** REV. A
SHEET 1 OF 5

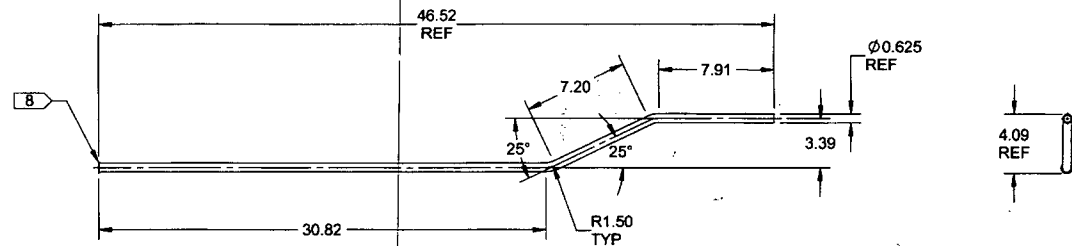
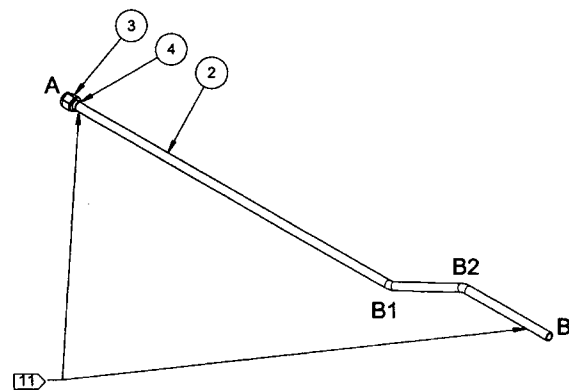
TITLE **DRAIN LINE** SCALE NTS

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM EAGLE COPTERS LTD



* ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	E4736-043	DRAIN LINE ASSEMBLY
2	1	E4736-3	TUBE
3	1	AN818-10D	NUT COUPLING
4	1	MS20819-10J	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	1.50	30.29	23.0°	0.0°
2	1.50	38.61	21.0°	174.0°
END B - TL	-	47.20	-	-



E4736-043 SERVICE DECK DRAIN LINE ASSEMBLY

E4736-3 TUBE

NOTES:

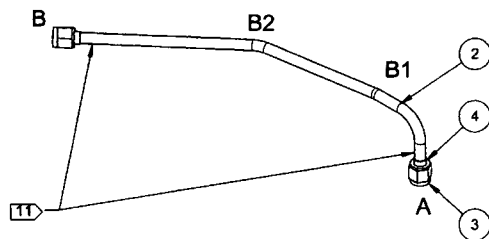
- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.625 \times 0.035$ WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T4T0.625W.035
OR
5052-O ALUMINUM ROUND TUBING, $\phi 0.625 \times 0.035$ WALL
PER AMS-VW-T-700/4 OR ASTM-B-210-02
REF DART SPEC. M5052-OT0.625W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.42 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 200 PSI
- 10) MARK LINE WITH BRADY B-999 "DRAIN" TAPE IN LOCATIONS SHOWN

DESIGN		EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	E4736	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		DRAIN LINE	NTS
DATE	12.11.01	COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.	

RELEASED
2013-11-28

* ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	E4736-045	DRAIN LINE ASSEMBLY
2	1	E4736-5	TUBE
3	2	AN818-6D	NUT COUPLING
4	2	MS20819-6J	SLEEVE COUPLING

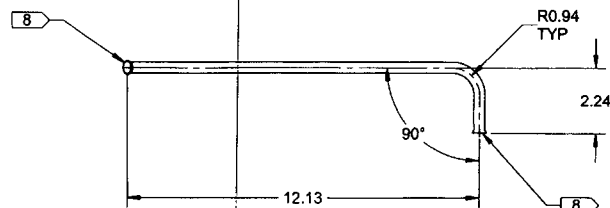
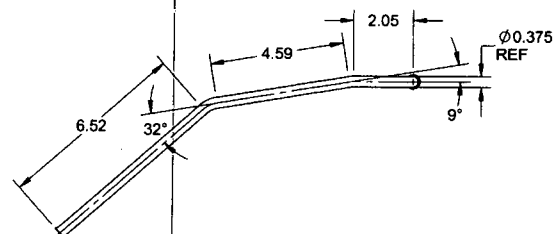
BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.94	1.32	88.0°	0.0°
2	0.94	8.81	32.0°	275.0°
END B - TL	-	15.71	-	-



E4736-045 FUEL FILTER DRAIN LINE ASSEMBLY

NOTES:

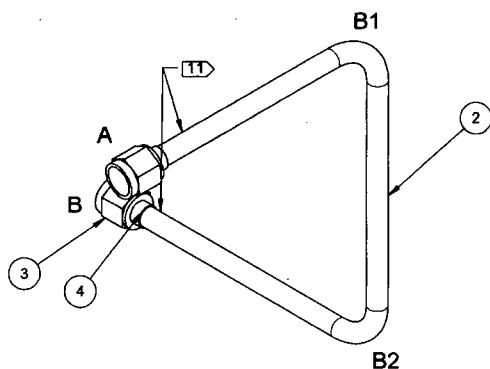
- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.375 \times 0.035$ WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T4T0.375W.035
OR
5052-O ALUMINUM ROUND TUBING, $\phi 0.375 \times 0.035$ WALL
PER AMS-VW-T-700/4 OR ASTM-B-210-02
REF DART SPEC. M5052-OT0.375W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 200 PSI
- 10) MARK LINE WITH BRADY B-999 "FUEL" & "DRAIN" TAPE IN LOCATIONS SHOWN



E4736-5 TUBE

DESIGN		EAGLE COPTERS LTD	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		E4736	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		DRAIN LINE	NTS
DATE	12.11.01	<small>COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.</small>	

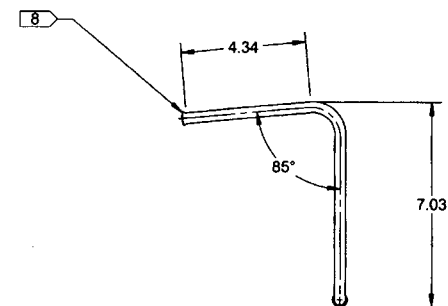
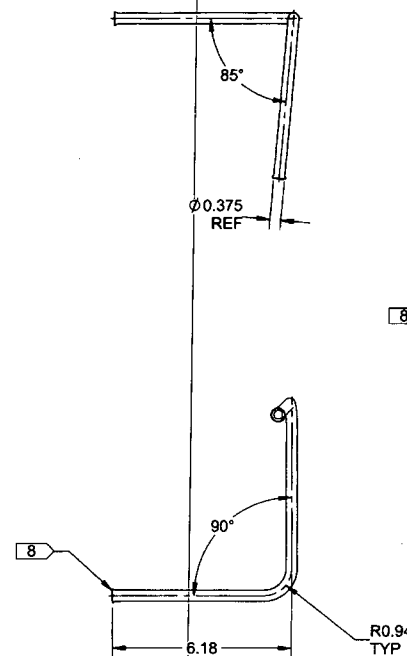
ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION
1	X	E4736-047	DRAIN LINE ASSEMBLY
2	1	E4736-7	TUBE
3	2	AN818-6D	NUT COUPLING
4	2	MS20819-6J	SLEEVE COUPLING



E4736-047 VENT LINE ASSEMBLY






NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.375 \times 0.035$ WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T4T0.375W.035
OR
5052-O ALUMINUM ROUND TUBING, $\phi 0.375 \times 0.035$ WALL
PER AMS-VW-T-700/4 OR ASTM-B-210-02
REF DART SPEC. M5052-OT0.375W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 200 PSI
- 10) MARK LINE WITH BRADY B-999 "FUEL" & "VENT" TAPE IN LOCATIONS SHOWN



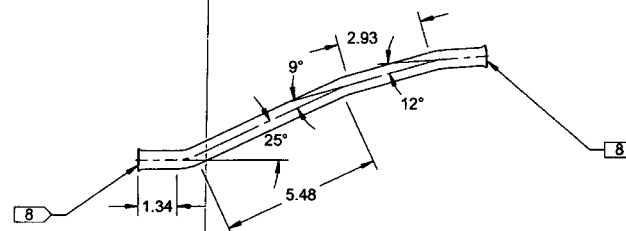
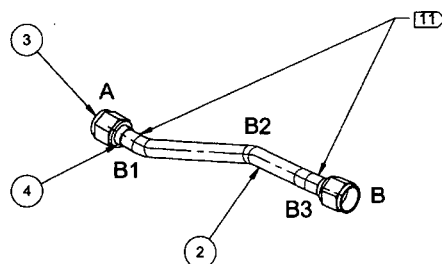
E4736-7 TUBE

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	0.94	4.44	98.0°	0.0°
2	0.94	10.72	88.0°	275.0°
END B - TL	-	17.34	-	-

DESIGN		EAGLE COPTERS LTD	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	E4736	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		DRAIN LINE	NTS
DATE	12.11.01	COPYRIGHT © 2012 BY EAGLE COPTERS LTD	
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RELEASED
2013-11-28

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	1.50	1.28	25.0°	0.0°
2	1.50	5.38	16.0°	278.0°
3	1.50	11.52	30.0°	150.0°
END B - TL	-	13.46	-	-



E4736-9 TUBE

1) MATERIAL: 6061-T4 ALUMINUM TUBING, Ø0.625 X 0.035 WALL
PER VW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M0601T4T0.625W.035
OR
5052-O ALUMINUM ROUND TUBING, Ø0.625 X 0.035 WALL
PER AMS-VW-T-700/4 OR ASTM-B-210-02
REF DART SPEC. M5052-0T0.625W.035

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 0.13 lbs

8) FLARE TUBE PER MS33584

9) PRESSURE TEST TO 200 PSI

10) MARK LINE WITH BRADY 8-999 "DRAIN" TAPE IN LOCATIONS SHOWN

RELEASE
2013-11-23

DESIGN	<i>JS</i>	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA DRAWING NO. E4736 TITLE DRAIN LINE COPYRIGHT © 2012 BY EAGLE COPTERS LTD <small>THIS DOCUMENT IS PRIVATELY PROPRIETARY, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF EAGLE COPTERS LTD.</small>	REV. A
DRAWN	<i>JS</i>		SHEET 5 OF 5
CHECKED			SCALE
MFG. APPR.	N/A		NTS
APPROVED	<i>JS</i>		
DE APPR.			
DATE	12.11.01		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22800

Purchase Order Date 1/27/2014

PO Print Date 2/4/2014

Page Number 1 of 3

Order From :

VC-FAC001

Ship To : DART AEROSPACE LTD

FIELD AVIATION COMPANY INC.
UNIT # 125 4300-26TH ST N.E.
CALGARY, ALBERTA, T1Y 7H7
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FA 22800
CL 46064

Contact Name

Vendor Phone 403-516-8200

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	E4736-041P	Fuel Filter Drain Line Assembly	4/10/2014		5.00	\$503.79	\$2,518.95
			Yes		Each		
			4/10/2014				
	FABRICATE AS PER DWG E4736 REV. A B111851						

2	E4736-043P	Service Deck Drain Line Assembly	4/10/2014		5.00	\$526.79	\$2,633.95
			Yes		Each		
			4/10/2014				
	FABRICATE AS PER DWG E4736 REV. A B111850						

Line Total: \$2,518.95

Line Total: \$2,633.95

Note:

2/4/2014

Field Aviation Company, Inc.
Unit # 125
4300 - 26th Street NE
Calgary AB T1Y 7H7
Phone: (403) 516-8200
Fax: (403) 516-8317



SHIPPED APR 01 2014

Date: 4/1/14
Customer #: 100310

Ship To #: 100310
Order #: 3810 SO
Branch/Plant: 101010

SOLD TO: Dart Aerospace
1270 Aberdeer
Hawkesbury ON
K6A 1X7

SHIP TO: Dart Aerospace
1270 Aberdeer
Hawkesbury ON
K6A 1X7



ORDER DATE	REQ'D BY	CUSTOMER PO	SHIP VIA
2014-01-27	2014-04-09	22800	Free On Board - Our Dock

LINE #	QTY ORD	QTY SHIP	ITEM #/ DRAW / REV	DESCRIPTION/ HS CODE	BATCH #/ LOCATION
2.000	5	5	TUBE FABRICATION C/SMPL	TUBE FABRICATION	SCA 111 12497- MF- 12495

Certification Clause:

I certify the items listed hereon have been fabricated, inspected and tested as applicable and conform to all specifications and requirements detailed in the contract or purchase order.

FABRICATED AS PER CUSTOMER SUPPLIED DWG
LN 1 - PN: E4736-041P FUEL FILTER DRAIN LINE
LN 2 - PN: E4736-043P SERVICE DECK DRAIN LINE
LN 3 - PN: E4736-045P FUEL FILTER DRAIN LINE
LN 4 - PN: E4736-047P VENT LINE ASSY
LN 5 - PN: E4736-049P SERVICE DECK DRAIN LINE

Authorized Inspector:  

Date: 1 APR 2014

SHIPMENT AUTHORIZATION BY:	BUYER:	PACKED BY:	SHIPPED BY:	RECEIVED BY:
